



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-100
Job Sheet 178621



Part No: SWA10A-100

Job Qty: 10 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA10A-100 Rev 10 IPP Rev A 17.12.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/15/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	10 pcs		6/15/18	0.00	10.00	MORI NLX		
120	QC	10 pcs		6/15/18	0.00	0.00	QC2		
130	QC	10 pcs		6/15/18	0.00	0.00	QC8		
140	Packaging	10 pcs		6/15/18	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea		6/15/18	0.00	0.00	QC21		

Part Op 110 - Cut blanks to 7.00" 1-Machine as per FOLIO. FC053 FOLIO REV: AA DWG REV: 10
Descriptions: 2-Deburr 3-***Please see PEC to change engraving batch # for every w/o**

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.750	17-4 SS H1150 Round Bar 2.750"	5.8000 ft (.58 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R2.750	6	4	0

Part Specifications

Specifications could not be found.

Plex 6/5/18 9:35 AM Dart.lajeunesse.marie



Container No: S085046



Part: SWA10A-100

Job No: 178621

Serial No/Batch: S085046

Revision: 10

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/28/18

DQA: _____ Date: _____



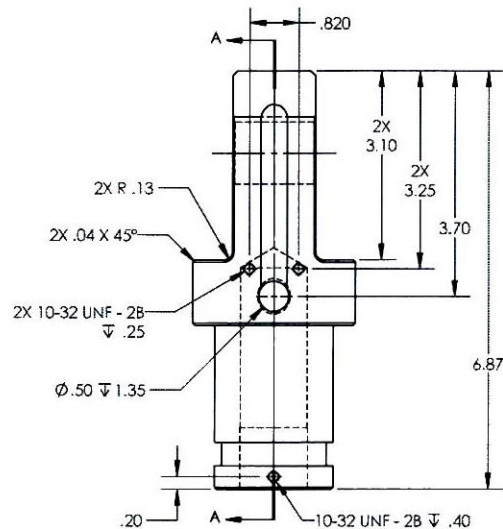
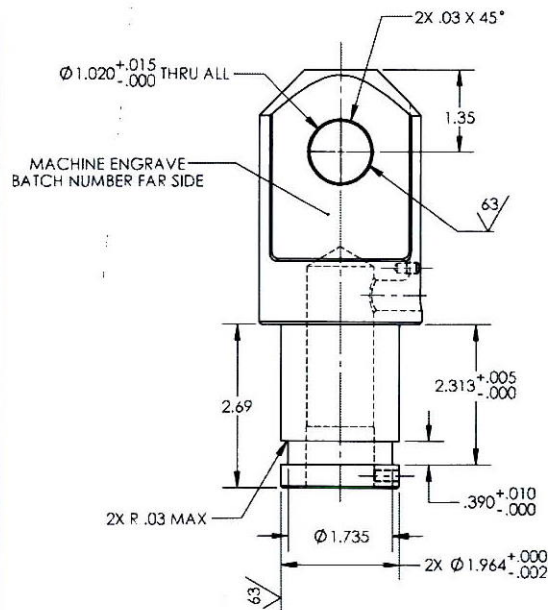
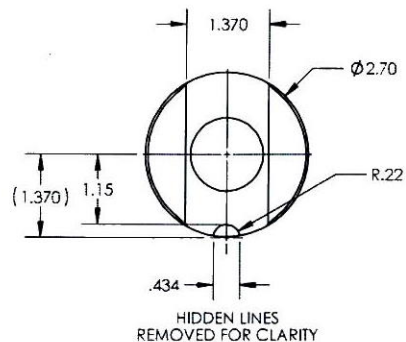
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

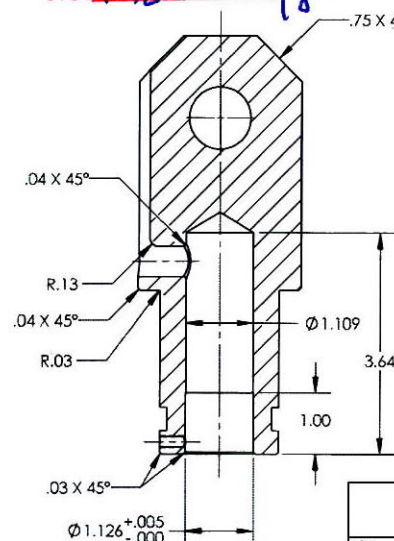
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

This drawing, specifications, and contents contained herein are the sole property of Dart Aerospace and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.



REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8		AS DRAWN BY CANAM	11/12/2012	JAG	
8A		CHD 8/0 TO SWA10A-100 BLANK	5/1/2014	JAG	RW
9	15-0161	UPDATED TO NEW DRAFTING STANDARDS. ADDED MATL OPTION 1/4 H1075. REMOVED SWA10A-100 BLANK FROM 8/0. ADDED DIMS FROM SWA10A-100 BLANK, CHD TOLERANCES ON NON-CRITICAL DIMENSIONS	7/17/2015	DPD	JAG
10	16-0243	ADDED MACHINE ENGRAVE BATCH NUMBER FAR SIDE NOTE.	12/1/2016	R/C	SM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178621 MJS-05
1806-05



DART AEROSPACE		TITLE LOWER END	
DWG NO. SWA10A-100		REV 10	
MATERIAL SS 17-4 H1150/17-4 H1075		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TREAT FRESH		XXX ± .005 FRACTIONS ± 1/8	
SPEC		XX ± .01 ANGLES ± 5°	
DRAWN BY: CANAM		X ± .1 SURFACES ± 125	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
DPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
QA APPR: LINDSAY		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
APPROVED: MACKOVJAK		USED ON MODEL	
SCALE 1:2	DATE 1/22/2002	SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-100	1	LOWER END	SS 17-4 H1150/17-4 H1075	

DART AEROSPACE LTD		Work Order: 178 621
Description: Lower End		Part Number:
Inspection Dwg: SWA101A-100 Rev: 10		Page 1 of 3

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.020	+/- .015 (-.000)	1.022			Mic LPO4	
1.350	±.005	1.350			H.G.	
.03x45°	+/- .010 x .5°	.03x45°			Vern LPO9	
2.69	±.01	2.690			H.G.	
1.735	±.005	1.736			Vern LPO9	
1.963	±.001	1.963			↓	
.395	±.005	.395			↓	
2.3155	±.0025	2.314			H.G.	
Ø2.70	±.01	2.699			Vern LPO9	
1.370	±.005	1.369			↓	
1.15	±.01	1.150			↓	
.434	±.005	.438			↓	
R.22	±.01	.219			↓	
.820	±.005	.820			↓	
R.13	±.010	.125			Rad gage	
.04 x 45°	±.01 x .5°	.04 x 45°			Vern LPO9	
10-32 UNF-2B	GO-NO GO	GO			↓	
.25	±.01	.260			↓	
Ø.500	±.005	.500			↓	
1.35	±.01	1.360			H.G.	
.200	±.005	.199			↓	
3.10	±.01	3.101			↓	
3.25	±.01	3.2485			↓	
3.70	±.01	3.701			↓	
6.87	±.01	6.868			↓	
R.13	±.01	.125			Rad gage	
R.03	±.01	.032			↓	
.03x45°	±.01 x .5°	.035x45°			Vern LPO9	

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 16-06-28	Date: 18/07/04	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

